



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEL133M-6201-101-3
Job Sheet 196617



Part No: RBEL133M-6201-101-3

Job Qty: 2 pcs *3 pcs B.P.*

Part Name: Bottom Rail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/17/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEL133M-6201-101 Rev 2 IPP Rev. A 19.05.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	NV5000 - 1	2	7/12/19	7/12/19	1.00	2.00	NV5000 - 1		
		pcs					NV5000 - 2		<i>Kt 19-06-25</i>
110	QC 2	2	7/12/19	7/12/19	0.00	0.00	QC 2 - 1		<i>Kt 19-06-25</i>
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S193453



Part: RBEL133M - 6201 - 101 - 3

Job No: 196617

Serial No/Batch: S193453

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 06/25/19

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	Conventional Mill - 1 - B4B	2 pcs	7/12/19	0.00 2.00	Conventional Mill - 1 - B4B	KT 19-06-25
					Conventional Mill - 2 - B4B	
130	QC 2	2 pcs	7/12/19	0.00 0.00	QC 2 - 1	KT 19-06-25
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	2 pcs	7/12/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	19-06-24
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	

DONE ON
NV 5000

				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150	Outsource - 4 - Anodize	2 pcs	7/12/19	GRO002-VC	2019-06-27
160	Packaging 2-1 - Receive - B4B	2 pcs	7/12/19	0.00 0.00	
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP JUL 0 3 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170	QC 6	2 pcs	7/12/19	0.00 0.00	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	DAS 40 JUL 0 4 2019 9-89
180	Packaging 3-1 - Stock - B4B	2 pcs	7/12/19	0.00 0.00	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	

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				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
190 QC 21 - SA	2	7/12/19	0.00 0.00		
	pcs				

Part Op 100 - 1-Machine as per folio FC 857 FOLIO REV: AA DWG REV: 2 2-Deburr

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - 1-Machine as per DWG. 2-Deburr

140 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG. AK

150 - Issue P/O; _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant - Material type; 6061T6 -Certificate of Conformity is required

160 - (Receive & Inspect for Damage & Mat'l Certs)

170 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X1.500 1.250	6061T6 Bar 1.000 X 1.500 1.250 <u>FK</u> 19-06-21	1.9200 ft (.96 ea)	100-NV5000 - 1	5168970

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-NV5000 - 1	M6061T6B1.000X1.500	2	20	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 196617
Description: M/R Damper Tool Kit (Bottom Rail)		Part Number: RBEL133M-6201-101-3
Inspection Dwg: RBEL133M-6201-101 Rev: 2		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.330	$\pm .005$	11.330			A1000	VERN.
9.900	$\pm .005$	9.899			3/006	H-G
.630	$\pm .002$	.636			—	G-P
.630	$\pm .002$	.630			—	G-P
1.180	$\pm .005$	1.180			MGP-04	VERN.
1.95	$\pm .010$	1.951			"	"
3.27	$\pm .010$	3.265			"	"
.8125	$\pm .0005$	.8125			—	G-P
.47	$\pm .010$	.469			—	G-P
2.48	$\pm .010$	2.475			MGP-04	VERN.
5.273	$\pm .005$	5.274			MGP-04	VERN.
1.56	$\pm .010$	1.563			"	"
.660	$\pm .005$	.660			"	"
30	$\pm .5^\circ$	30			—	A-G
.590	$\pm .005$	.590			MGP-04	VERN.
1/4-28	GO-NOGO	1/4-28				
.490	$\pm .005$	.489				
.465	$\pm .005$	.467				
.980	$\pm .005$	.9805			MGP-01	Mic
.283	$\pm .005$	.283			MGP-04	VERN.
.490	$\pm .005$	.490			"	"
.1869	± 0.0075 -0.0	.1872			—	G-P

DAS

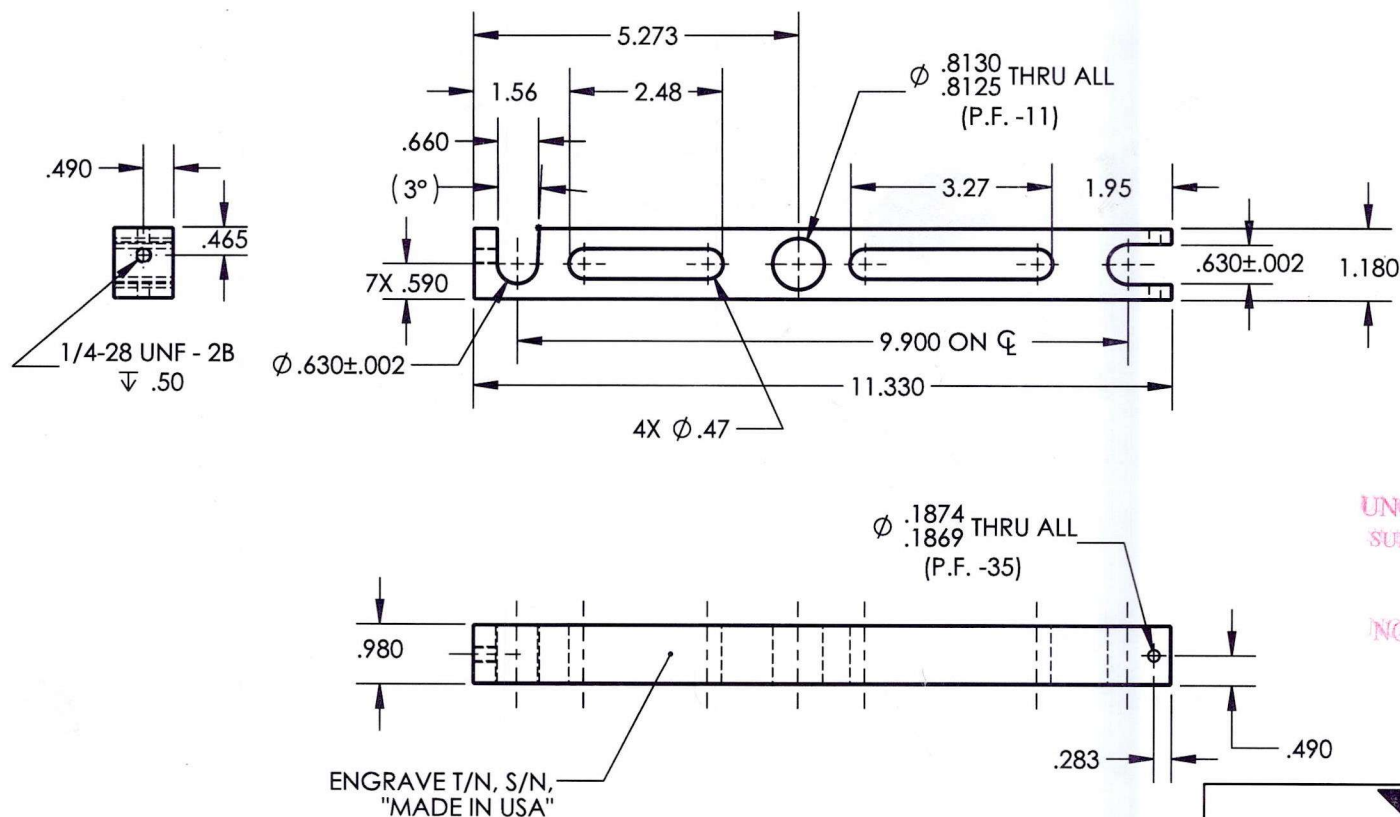
Measured by: AL.A. K&	Checked by: 20 9-00	QC Inspector:
Date: 19-06-25	Date: 19-06-26	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0223	-3 CH'D DIM WAS 1/4-28 UNF THRU TO ID IS 1/4-28 UNF -2B ∇ .50, WAS $\varnothing$.8130/.8125 THRU ALL IS $\varnothing$.8130/.8125 THRU ALL (P.F. -11), WAS $\varnothing$.1875/.1873 THRU ALL IS $\varnothing$.1874/.1869 THRU ALL (P.F. -35), ADDED ENGRAVE NOTE.	11/15/2016	RJC	SM



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 196617 MGS
1906-17

ENGRAVE T/N, S/N,
"MADE IN USA"

(3)
BOTTOM RAIL

DART AEROSPACE	
TITLE M/R DAMPER TOOL KIT	
DWG NO. RBEL133M-6201-101-3	REV 2
MAT'L 6061 HEAT TREAT FINISH CLEAR ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS I	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125/	
DRAWN BY: GILBERT CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL EUROCOPTER
SCALE 1:3	DATE 2/14/2012 SHEET 4 OF 14

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Under Review Notification

Raised By: Ketan Tailor

Product #: RBEL133M-6201-101

Date: May 23, 2019

Product Name: M/R DAMPER TOOL KIT

Part Number (D-Part and 9-Digit) (eg. D3535-11) (eg. D3535-25) (eg. D206-642-143) (eg. RBEM324U3010101-1)	Drawing or Document & <u>Current</u> Affected Revision for each part listed	"Y" or "N" Required for Each Part Do not leave blank							Reserved ECN / URF Log Number	Instructions Relevant to Each Part (including whether CHG #'s will be affected)
		DO NOT SHIP	Red Tag/Quarantine Stock	Advise Customers	Hold all Production	Re-Work Stock	IPP Under Review (Engineer Signoff Required.)	Put Product Specifications Under Review ("Bluefiles")		
RBEL133M-6201-101	RBEL133M-6201-101 REV. 2	Y	Y	N	Y	Y	N	N	19-733	Remove item -43 from BOM
RBEL133M-6201-101-45	RBEL133M-6201-101 REV. 2	Y	Y	N	Y	Y	N	N	19-733	Remove cutout for item -43

Description of Issue:

Item -43 is referencing the wrong T/N, and should not be included in the kit

Current orders for this tool may be shipped with engineering sign off. See VM for more information.

Distribution:

VP Operations

Director of Operations

Director Quality Assurance

QC Coordinator

Director of Engineering

Chief Engineer

Engineering Project Managers

Engineering Clerk

Customer Support Manager

Production Engineers

Production Planners

Purchasing Manager

Technical Support

Product Manager - Solutions Provider

Supply Chain Director / Senior Buyer

Marketing Eugene



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043867



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043867

PO Date: 6/27/19

Due Date: 7/5/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-06-28

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183516	C2-11-1	Side Plate, Solenoid -Issue P/O to Groupe Altech -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	7/5/19	8 pcs	0 pcs	8 pcs	\$15.00/pcs	\$120.00
2	196617	RBEL133M- 6201-101-3	Bottom Rail -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	7/5/19	3 pcs	0 pcs	3 pcs	\$40.00/pcs	\$120.00
Grand Total:											\$240.00



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043867



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/28/19 11:04 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020381-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

020381- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.			
03-Jul-2019		SVETLANA DORZHIYEVA		POHB043867			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/ Back Order
1	C2-11-1 Rev.	C2-11-1 ANO-BLACK [ANODIZE BLACK] PER IAW MIL-A-8625F TYPE 2, CLASS 2 WATER SEALANT	ANODIZE CH	8	8	0	0
2	RBEL133M-6201-101-3 Rev.	RBEL133M-6201-101-3 ANO-CLEAR [ANODIZE CLEAR] PER IAW MIL-A-8625F TYPE 2, CLASS 1 WATER SEALANT	ANODIZE CH	3	3	0	0

DAS
40
9-89

RECEIVED
 JUL 03 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

2 BOXES

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

JP JAY

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

C 3/7/19
11:33 am